Work Orde	er ID 108421 1:30:30 PM			*108	3421*						···	Page 1
Item ID: Revision ID: Item Name:	D3161-3 Hinge			Accept	*N900	040	100) * :	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:		ety: 10.00 Qty: 10.00	*10* *10*		Cust Item I Customer:	D:				.		
Approvals:	Process Plan: M	しつ	Date: 13-15-2	Tooling:	Da	ate:	_]	Run	Start	*N	R1*
	QC:				Da	ate:	·			Stop	*N	R2*
Sequence ID/ Work Center II	Operati D Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r ;										and any one of the second seco
D3161	Rev A2											
100 *100* Small Fab	Small Fat	Memo		0.00				10x				13/10
Small Fab			th as per dwg (15.0" long?) and punch end of hinge	close.Deburr if							, ,
110	QC5- Ins	pect part comp	leteness to step on W/O	0.00 DAS				10				

*11**0***

Quality Control

0.00 1510 23

Identify as per dwg & Stock Location: 5703

120

Packaging

Memo

0.00

 10×28 9-89

DAS 36 9-89

120

Packaging

Memo

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	O	NFORI	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	ė.			:	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No				Rework Scrap Use-as-is Work Order Update Skid-tube Crosstube Machining Thermoforming Large Fab Composite		→	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root				Descri	ption of work order update	ı	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved								CODY				
£ 1°-			General	AUL	T CATE	GORY						
Landir	Cracks Crushed/ Crushed/ Cuffs Heat Trea Inspectio Ripples in	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes			Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	Torque Waves in Extrusion Drawing		1	loncou	Lanuration							

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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Work Orde						*108	8421*						-	Page	2
Revision ID:	D3161-	3			A	Accept	*N900	040	100	*	Setup	Start Stop	*N:	S1*	
	10/17/13	•	y: 10.00 ty: 10.00		*10* *10*		Cust Item I Customer:	D:			_		7 4		
Approvals:	Proces	s Plan:		Date:		Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II)	Operatio Descripti OC21- Fina		Work Order R	Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp	
130		_	Memo			0.00					A	/11/	13-60	1-20	_

Quality Control

AB-1033

												DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	PDATE		·		
												QA Closed:	Date:	
Work Orde	ri:					DISPOSITION				AGAIN	IST DE	PARTMENT	/PROCESS	
Part No. NCR No. Descri			Rework Scrap Use-as-is Work Order Update	Machining Small Fab Thermoforming Finishing Large Fab Composite		ab ing	i	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other					
Root					Descri	ption of work order update		nitial	A	ction		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
						F	AUI	T CATE	GORY					-
Landir	ng G	Gear			_	General	_	-			_	•		-
	Centre Not Concentric to O/S BO		Bend BOM/Route Broken/Damaged	Grain Hardware Inspection Incomplete				Ovalized Over/Under Part Incorred	<u> </u>	Pressure/Forced Temperature/Cure Weld				

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination Countersink

Cut Too Short

Drill Holes

Drawing Finish

Folio

3. 8.

Picklist Print

October-17-13 1:30:30 PM

Work Order ID:

108421

Parent Item:

D3161-3

Parent Item Name:

Hinge

Start Date: 10/17/13

Required Date: 10/17/13

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A02.04.26New IssueNG

IPP Rev:B 08-04-29 update seq. 1 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	D
MS20257-3-7200 Piano Hinge		Purchased	No			100	f	64.2816	1.44-	15.157895	U	10	23_	_;
				Location		Loc Qty	<u>Lo</u>	c Code			•	′ /		
				ST209a		64.2815788								
				12	3960	2.2447368			6	, - , ``	127			
				m	26275	26.036842			84 +	19	110			
				m]	127172 -	36			2x	T88 3.	09			

						1.6
				DQA:	Date:	
WORK ORDER NON-O	ONFOR	MANCE / UF	PDATE	-		
				QA Closed:	Date:	
DISPOSITION			AGAINST DE	PARTMENT/	PROCESS	
Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
tion of work order update	Initial	A	ction	Sign &		
r Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
	AULT CATI	GORY				
General			Γ	1		7
Bend BOM/Route	├			Ovalized	tolorance	Pressure/Forced
BOM/Route Broken/Damaged	-	are tion Incomplete	<u> </u>	Over/Under	<u> </u>	Temperature/Cure Weld

Landing (Gear	General					_
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Г	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Г	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Г	Maintenance		Part Moved	 -
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		_	
	Torque Waves in Extrusion	Drawing	Γ	Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions		-	

Description of work order update

or Non-conformance

NCR:

Root

Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved

Yes / No

Work Order:

Part No.

Step

Qty

NCR No. _____

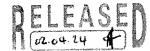
Date

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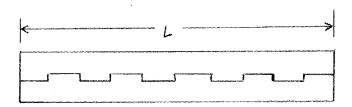


DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ON	
CHECKE		DRAWING NO.	REV. A
DATE	2.04.24	TITLE HINGE	SCALE NTS
1	02 nu 24	VEW YOUE	



	02.04.24	HINGE	1417
Α	02.04.24	NEW ISSUE	
ΑI	十年04.02.27	ADDED D3161-5	
A 2	11-11-04.06 30	ADD 03161-7 & 03161-9	
•	*		THE CONTROL OF THE PARTY OF THE

P/N	LENGTH 'L'	DESCRIPTION
D3161-1	13.5"	HINGE (REPLACES MS 20257-3-13.5 ON DZ183)
D3161-3	15.0"	HINGE (REPLACES MS 20257-3-150 ON D2950-041)
D3161-5	9.9"	HINGE
03161-7	14,0"	HINGE
03161-9	17.0	HINGE



NOTES:

1) MAKE FROM MS20257-3-7200 HINGE

12-0-21 13-1 MCZ